

# Work Order ID 51089

July 30, 2009 4:04:06 PM



Page 1

Item ID:	D2332-045	Accept		Setup	Start	
Revision ID:	C1				Stop	
Item Name:	Lid Prop Assembly 7.25" long					
Start Date:	07/31/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	08/05/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	<i>09-07-31</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2332	Rev C1

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Cut to length as per Dwg D2332 (D2332-7) Locking Collar <input type="checkbox"/> Cut to length as per Dwg D2332 (D2332-5) Stop Pin <input type="checkbox"/> Deburr								

*m-l* *09/08/04*

110		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch or form to length as per Dwg D2332 (D2332-21) using DT8012 <input type="checkbox"/> Note: Make (2) D2332-21 Prop Arms per assembly.)								

*m-l* *09/08/04*

120		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill hole in D2332-21 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) <input type="checkbox"/> 2-ensure no foreign objects inside fo tube and deburr								

*m-l* *09/08/04*

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Item ID: D2332-045

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

=&gt; 5 09/08/04

(42)

/



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Weld D2332-21 and D2332-5 as per Dwg D2332 & QSI 004 using Welding Jig DT8298. (Weld 1 per assembly) ☐ Identify as D2332-23 ☐ \*\*\*\*\* insure nothing is inside of tube before welding \*\*\*\*\* ☐ A/R SS Rod  
Batch: 1109213 ☐ \*\*\*\*\*brush weld r

09-08-04

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

09-08-04

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Item ID: D2332-045

Accept



Setup Start



Revision ID: C1

Stop



Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/05/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

=&gt; 5 09/08/04

QC

Memo

0.00

(40)

6

Quality Control

170

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

Tumble

13 9-8-5

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Tumble 2-Assemble as per Dwg D2332

13 9-8-5

LD EB 09/08/05 ①

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190

0.00

0.00

$\Rightarrow \delta \cos \theta \cos \phi$



Identify as per dwg & Stock Location: 5/2

0.00

0.00

9/8/5 K SP

QC21- Final Inspection - Work Order Release

0.00

0.00

mf 09-08-05 A

# Picklist Print

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Page 1/3

Work Order ID: 51089

Parent Item: D2332-045RevC1

Parent Item Name: Lid Prop Assembly 7.25" long


Comments:

Start Date: 07/31/2009

Required Date: 08/05/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A  Bolt		Purchased	No			180	Each	150.0000	1.0000			

*Eg 809/08/05*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	150	
101291	3	
106918	1	
108138	60	
111295	86	

AN960JD416L



Washer

Purchased

No

180

Each

641.0000

3.0000

*Eg 809/08/05*

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	641	
107008	54	
108138	4	
108583	42	
110153	541	

*3*

# Picklist Print

July 30, 2009 4:04:06 PM

Work Order ID: 51089

Parent Item: D2332-045RevC1

Parent Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009

Required Date: 08/05/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			110	f	24.8100	0.1140			

304 SS Round bar .250

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	24.81	
107387	24.81	

m-h 09/08/04  
M107389

M304TR0.500W.035 Purchased No

180 f 358.5862 1.6228



304 RD Tube .500 x .035W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	358.5862097	
108250	2.23	
111097	24.687936	
111704	31.6682737	
112187	300	

m-h 09/08/04  
M112187

M304TR1.000W.049 Purchased No

100 f 61.9900 0.4441



304 RD Tube 1.00 x .049W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	61.99	
108756	14.92	
111457	47.07	

m-h 09/08/04  
M111457

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Shop Packet Print

# Picklist Print

July 30, 2009 4:04:06 PM

Work Order ID: 51089



Parent Item: D2332-045RevC1



Parent Item Name: Lid Prop Assembly 7.25" long

Start Date: 07/31/2009

Required Date: 08/05/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			100	Each	10,286.00	1.0000			



*9/09/08/05*

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10286

107499

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110507

2240

111827

6000

112314

2000

15924

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8182

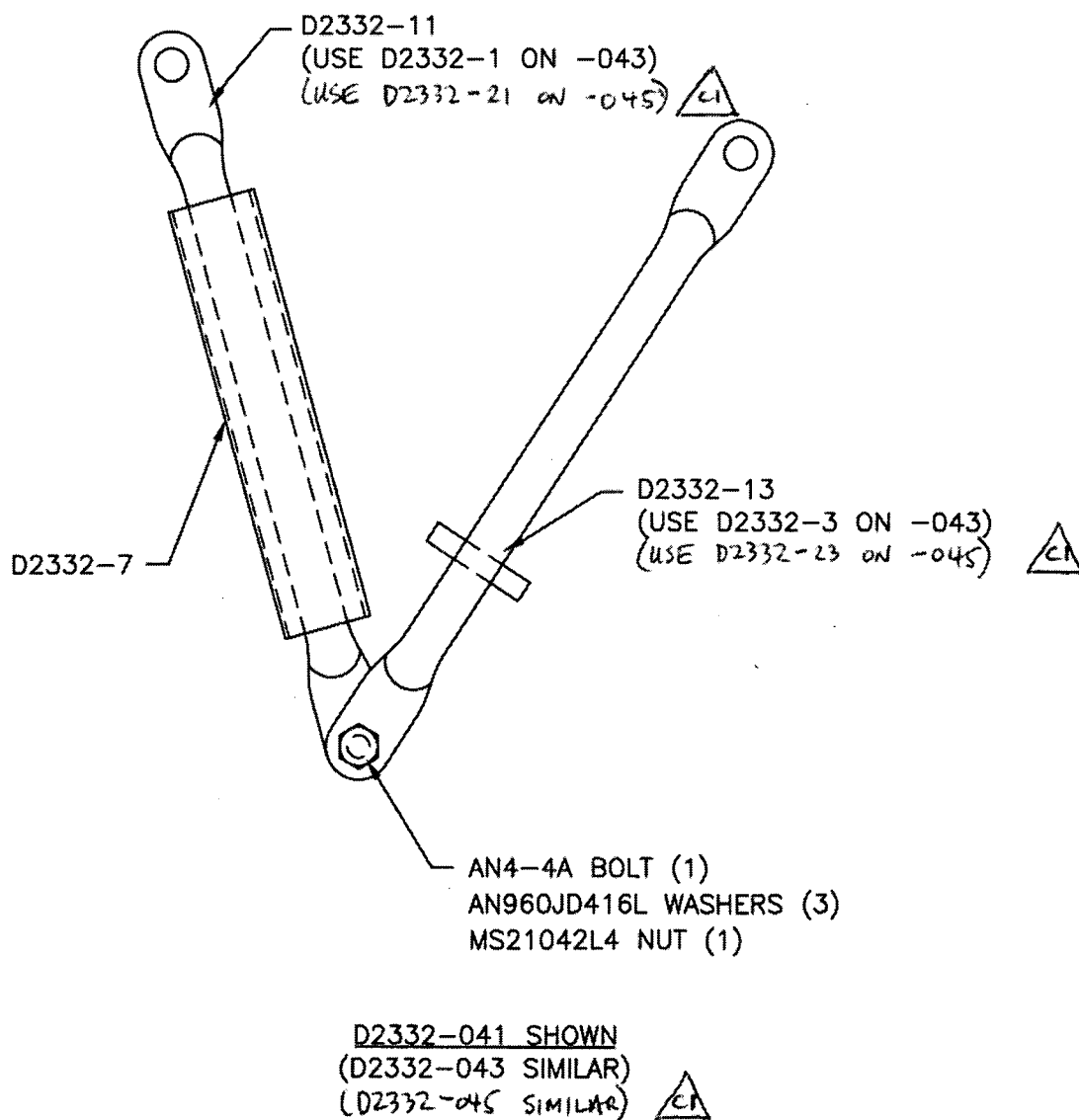
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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04

#51089  
mk-07-31  
09-08



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**DART**



**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. C

SHEET 2 OF 2

SCALE

DESIGN  
#  
DATE  
03.07.03

CHECKED  
#

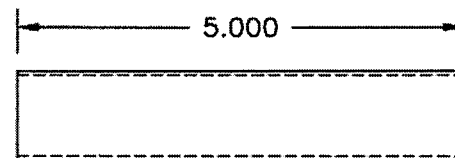
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APPROVED  
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DRAWING NO.  
D2332

TITLE  
LID PROP ASSEMBLY

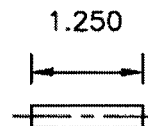
1:2

C	#	03.07.03	MAKE - 041 PROP 6.69" LONG (5th)
C1	#	03.08.06	MAKE - 043 PROP 8.00" LONG (1st)
			ADD - 045 PROP (7.25" LONG)

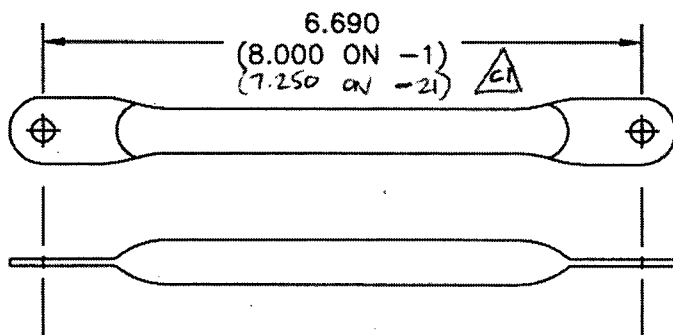


D2332-7 LOCKING COLLAR

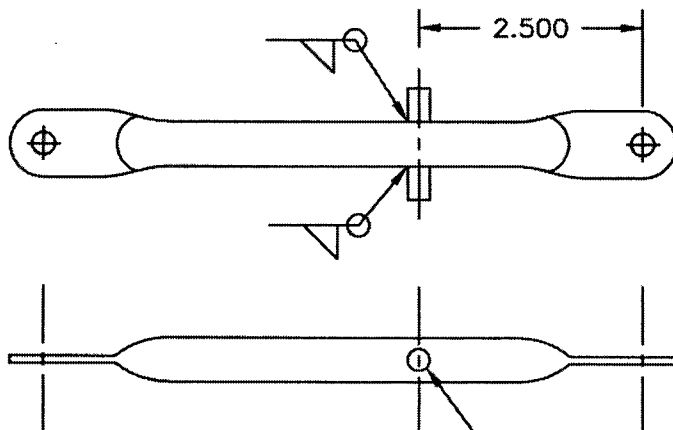
*#51089*  
*M/F*  
*09-07-31*



D2332-5 STOP PIN



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13  
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.07.04